

Day:  
User:Monday, 7/16/2007 2:44:11 PM  
Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BALL STUD
Job Number : 33554	
Estimate Number : 12841	
P.O. Number : <i>NIA</i>	Part Number : D36221
This Issue : 7/16/2007 S.O. No. : <i>NIA</i>	Drawing Number : D3622 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 33553	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 7/23/2007
Checked & Approved By : <i>[Signature]</i> 07.07.17	Qty: <i>30</i> Um: Each
Comment : Est Rev. A New Issue 07-04-24 JLM	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303H0500 303 HEX BAR



Comment: Qty.: 0.1134 f(s)/Unit Total : 2.2680 f(s)

303 HEX BAR .500"

Batch: *M102286**2.8/20 07/08/07*

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA686 &amp; DWG D3622 ,

FOLIO REV: *[Signature]*DWG REV: *[Signature]*

2-DEBURR AS REQUIRED

*2.8/20 07/08/07*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*(35)**2.8/20 07/08/07*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*7/07-08-07*

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST**7/07-08-07 35*

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL STUD

Job Number: 33554

Part Number: D36221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(35)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/08

Job Completion



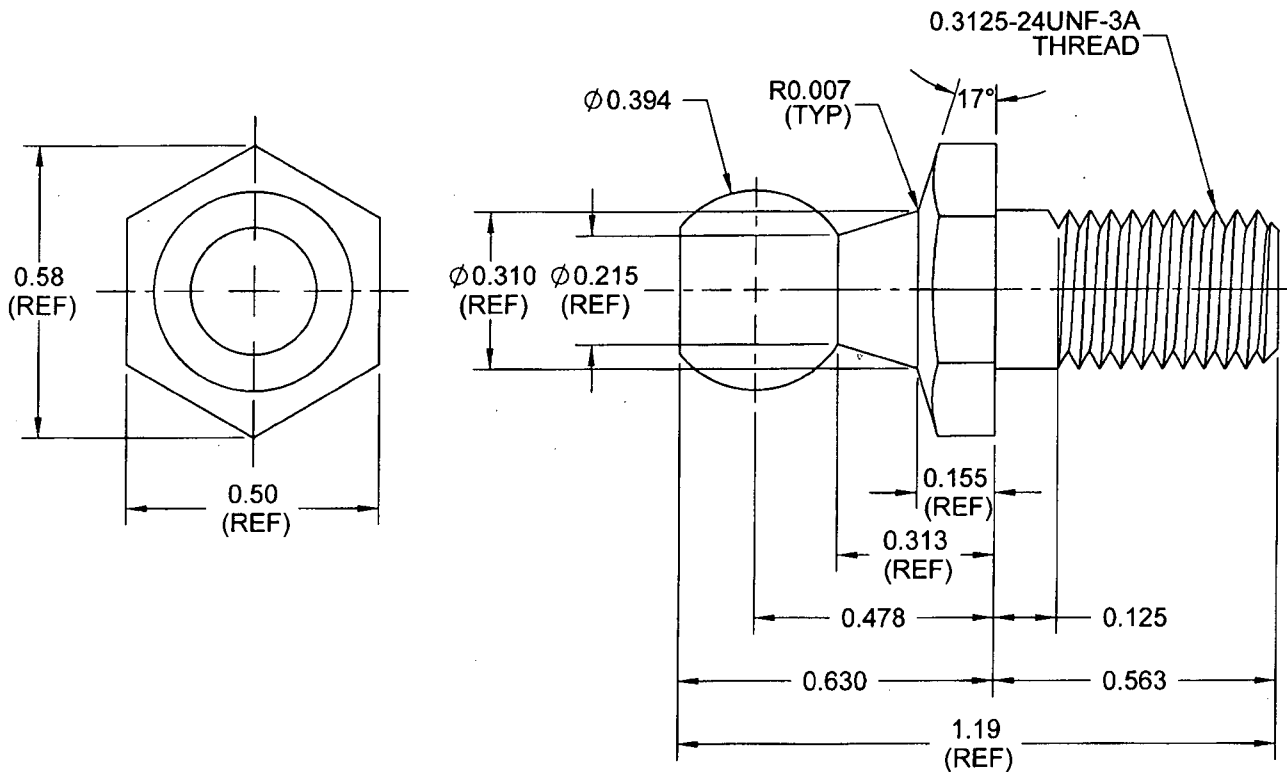
07-08-07

**DART**

DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. <b>D3622</b>	REV. A SHEET 1 OF 1
DATE <b>07.04.13</b>		TITLE <b>BALL STUD</b>	SCALE NTS
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**RELEASED**  
07.07.11

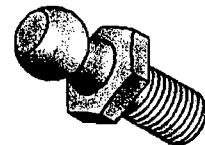
Per BCW# 1007

**D3622-1 BALL STUD**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **33554**

**NOTES:**

- 1) MATERIAL: AISI 303 HEX BAR (REF. DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b>	
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.3125-24	.3125/.305	.310				
	PD	.285/.282	.285				
	.563	+/- .010	.563				
	.125	+/- .010	.125				
	.155	+/- .010	.150				
	.313	+/- .010	.310				
	.478	+/- .010	.478				
	.630	+/- .010	.631				
	1.19	+/- .030	1.193				
	.394 Ø	+/- .010	.3935				
	.310 Ø	+/- .010	.305				
	.215 Ø	+/- .010	.215				
	.58 Ø	+/- .030	.570				
	.50	+/- .030	.498				
	R.007	+/- .010	.015				
SIDE B	17°	+/- 1/2°	17°				

<b>Measured by:</b> <i>RP/S.F.</i>	<b>Audited by:</b> <i>SD</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <i>07/08/07</i>	<b>Date:</b> <i>07-08-07</i>	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	